

**\*84183\***

Page 1

**\*N900040100\***

Setup Start \*NS1\*

Stop \*NS2\*

**Start Date:** 5/7/2012      **Start Qty:** 1.00      **\*1\***

**Cust Item ID:**

**Required Date:** 5/9/2012      **Req'd Qty:** 1.00      **\* 1 \***

**Customer:**

**Reference:**

Approvals: \_\_\_\_\_ Process Plan: MF Date: 12-05-07 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start \*NR1\*  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop \*NR2\*

Draw Nbr	Revision Nbr
D4097	A

100

0.00

**\*100\***

### Small Fab

## Memo

0.00

## Small Fab

1- Assemble as per dwg

110

QC5- Inspect part completeness to step on W/O

0.00

\*110\*

QC

## Memo

0.00

## Quality Control

120

Identify as per dwg & Stock Location:

0.00

**\*120\***

## Packaging

## Memo

0.00

## Packaging

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 84183****\*84183\***

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Monday, May 07, 2012 10:39:10 AM

Item ID: D4097-041      Accept      **\*N900040100\***      Setup      Start      **\*NS1\***  
Revision ID:      Stop      **\*NS2\***  
Item Name: Armrest Assembly  
Start Date: 5/7/2012      Start Qty: 1.00      **\*1\***      Cust Item ID:  
Required Date: 5/9/2012      Req'd Qty: 1.00      **\*1\***      Customer:  
Reference:

Approvals:      Process Plan:      Date:      Tooling:      Date:      Run      Start      **\*NR1\***  
QC:      Date:      SPC (Y/N):      Date:      Stop      **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130	QC21- Final Inspection - Work Order Release	0.00							
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**\*130\***

QC      Memo      0.00

Quality Control

12/5/89  
ME  
12-05-08

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Monday, May 07, 2012 10:39:10 AM

Page 1

Work Order ID: 84183

Parent Item: D4097-041

Parent Item Name: Armrest Assembly

Start Date: 5/7/2012

Required Date: 5/9/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A as per ECN10-573 DD 10.05.18 verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3696-041 Arm Assembly		Manufactured	No			100	Each	4.0000	1	1		5/12/05/07	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST262		4							
				58895		4							
D4098-041 Armrest Cushion Assembly		Manufactured	No			100	Each	2.0000	1	1		5/12/05/07	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST261		2							
				58885		2							
D4099-1 Bracket		Manufactured	No			100	Each	5.0000	1	1		5/12/05/07	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				GA		5							
				83590		5							
MS21042L3 Nut		Purchased	No			100	Each	2,985.0000	3	3		5/12/05/07	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST300		2985							
				117885		32							
				118927		2							
				119017		1121							
				119075		138							
				121349		698							
				121444		994							
										3			

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Monday, May 07, 2012 10:39:10 AM

Page 2

Work Order ID: 84183

Parent Item: D4097-041

Parent Item Name: Armrest Assembly

Start Date: 5/7/2012

Required Date: 5/9/2012

Start Qty: 1.00

Required Qty: 1.00

MS24693-C273

Purchased

No

100

Each

125.0000

5

5

Screw

Location

Loc Qty

Loc Code

ST310

125

120308

25

121060

100

MS24693-C277

Purchased

No

100

Each

48.0000

3

3

Screw

Location

Loc Qty

Loc Code

ST310

48

109297

12

113644

36

NAS1149D0332J

Purchased

No

Each

2,277.0000

3

Washer

Location

Loc Qty

Loc Code

ST298

2277

105793

12

110985

4

117087

89

119042

32

119717

507

120644

122

121011

1511

Monday, May 07, 2012 10:39:10 AM

Shop Packet Print

Page 2

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

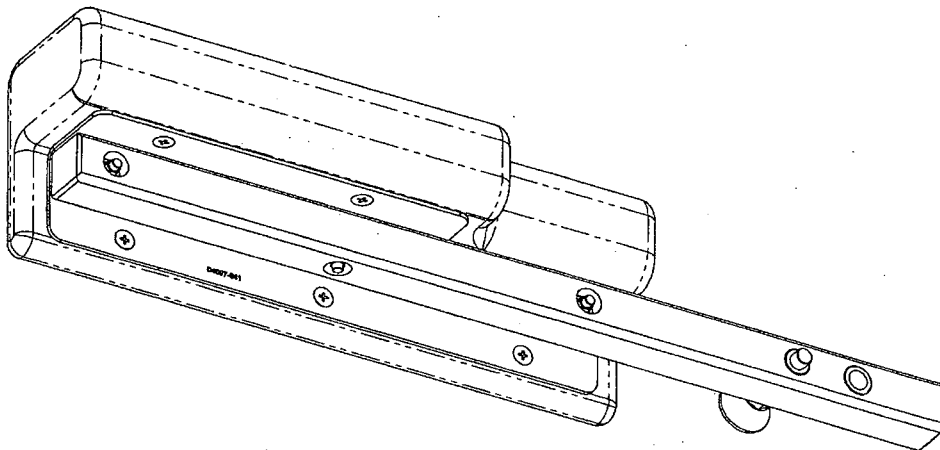
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



8 7 6 5 4 3 2 1

ITEM	QTY	P/N	DESCRIPTION
1	X	D4097-041	ARMREST ASSEMBLY
2	1	D3696-041	ARM ASSEMBLY
3	1	D4098-041	CUSHION ASSEMBLY
4	1	D4099-1	BRACKET
5	3	MS21042L3	NUT
6	5	MS24693-C273	SCREW
7	3	MS24693-C277	SCREW
8	3	NAS1149D0332J	WASHER (OR AN980JD10L)



**D4097-041 ARMREST ASSEMBLY**

#54183

**RELEASED**  
2010-05-17  
mb

A	NEW ISSUE	MB	10.05.07
REV.		DESCRIPTION	BY DATE
DESIGN		<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN		DRAWING NO. D4097	REV. A
CHECKED		SHEET 1 OF 2	
MFG. APPR.		TITLE	SCALE
APPROVED		NTS	
DE APPR.		ARMREST ASSEMBLY	
DATE	10.05.07	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR DISSEMINATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

8 7 6 5 4 3 2 1

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

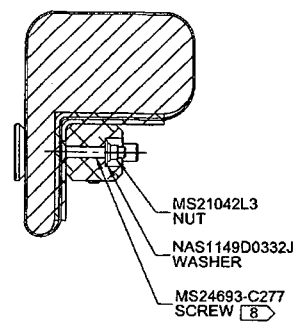
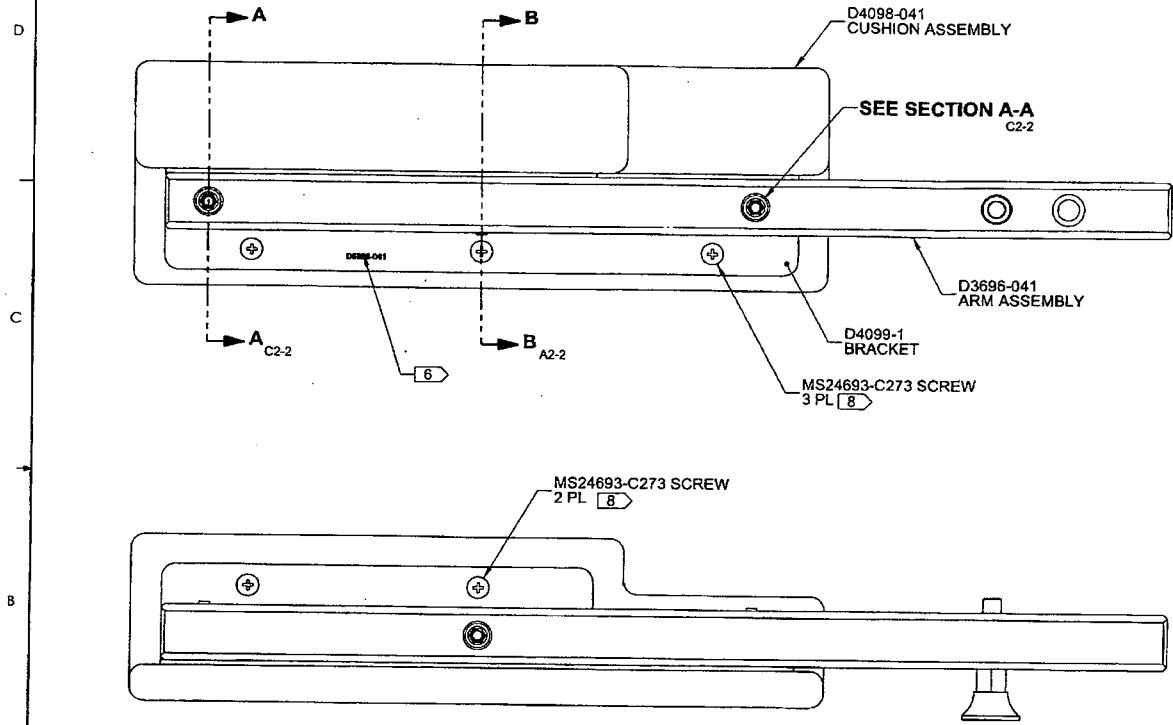
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

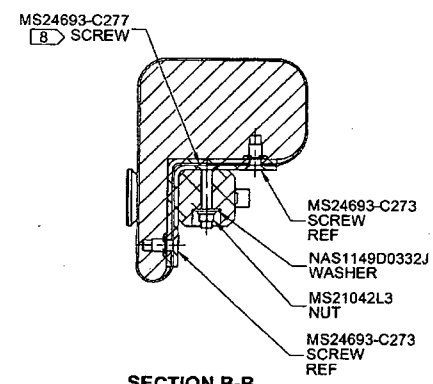
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

8 7 6 5 4 3 2 1



SECTION A-A  
C7-2  
D4-2



SECTION B-B  
C6-2

**RELEASED**  
2010-05-17  
MP

- NOTES:**
- 1) MATERIAL: NONE
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: NONE
  - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4097-041" USING FINE POINT PERMANENT INK MARKER LOCATED APPROXIMATELY AS SHOWN
  - 7) WEIGHT: 2.66 lbs
  - 8) TORQUE SCREWS TO 20-25 in.-lb.

#84153

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4097	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		ARMREST ASSEMBLY	NTS
DATE	10.05.07 -	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

8 7 6 5 4 3 2 1

# Dart Aerospace Ltd

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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries